



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4682-043
Job Sheet 202331



Part No: D4682-043

Job Qty: 2 pcs

DAS
21
9-89

Part Name: Wearplate Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/24/19

Job Tracking No:

Due Date: 11/1/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D4682 REV:F DSK179 REV:A IPP REV:A 13.03.27 NEW ISSUE DD VERF:JLM IPP REV:B 13.11.14 AS PER DWG REV.B DD VERF:JLM IPP REV:D 14.11.24 AS PER DWG REV.C DD VERF:JLM IPP REV:E 15.06.10 AS PER DWG REV.D DD VERF:JLM IPP REV:F 19.09.23 AS PER DWG REV.E DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	2 pcs	11/1/19	11/1/19	0.17	0.50	Waterjet - Flow		JRB 10/26/19
120	QC 2	2 pcs	11/1/19	11/1/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		

Plex 10/24/19 2:47 PM Dart.lajeunesse.marie

130 QC 8	2 pcs	11/1/19	0.00 0.00	QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	ALV JRB 10/26/19
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	OCT 28 2019 DAS 40 9-89
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
140 Small Fab - Brake NC - B4B	2 pcs	11/1/19	0.25 0.33	Small Fab - Brake - 1 - B4B	DAS 30 9-89 OCT 28 2019
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	
150 QC 5	2 pcs	11/1/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	OCT 29 2019 DAS 40 9-89
				QC 5 - 61	
				QC 5 - 81	
155 Automated Welding - B4B	2 pcs	11/1/19	0.25 0.33	Automated Welding - 1 - B4B	AL

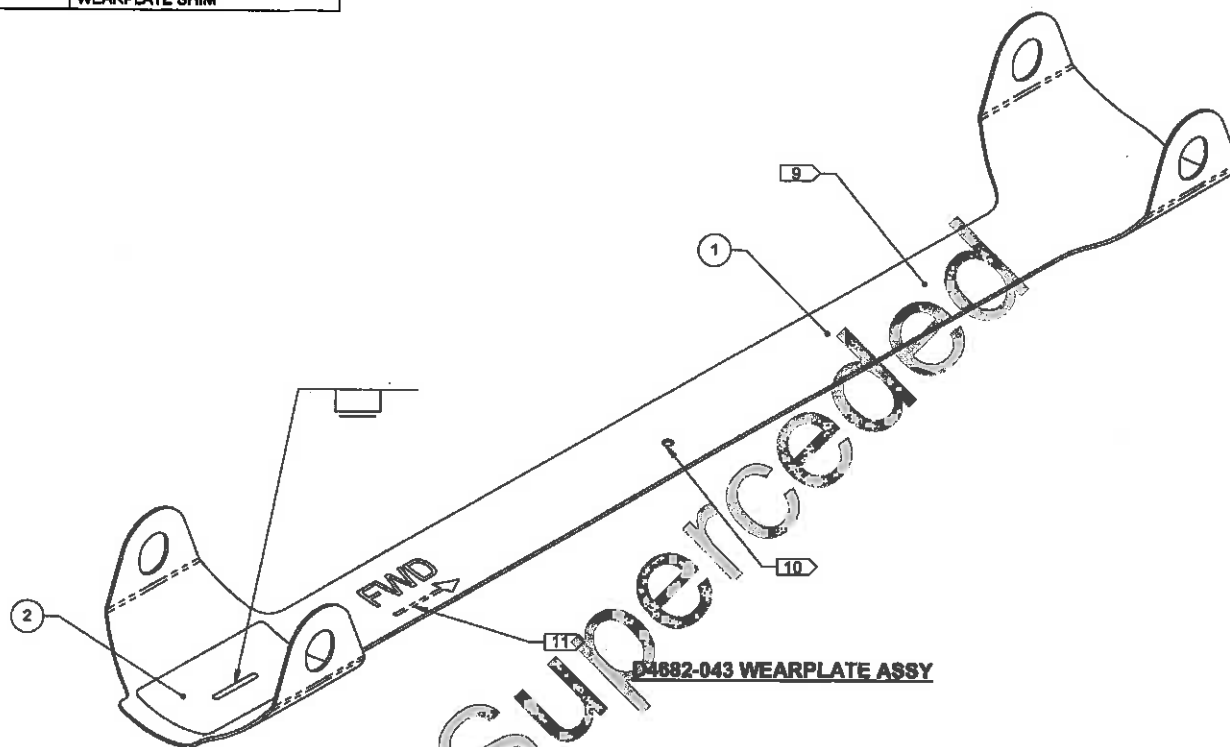
160 Large Fab - Welded Assy-2-B4B	2 pcs	11/1/19	0.00 1.00	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
				Large Fab - 12 - B4B	
170 QC 9	2 pcs	11/1/19	0.00 0.00	QC 9 - 10	DAS 24 9-89
				QC 9 - 18	
				QC 9 - 24	
				QC 9 - 43	
				QC 9 - 50	
				QC 9 - 9	
180 QC 5	2 pcs	11/1/19	0.00 0.00	QC 5 - 10	DAS 24 9-89
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
190 Spray Paint - 2 - B4B	2 pcs	11/1/19	0.00 0.17	Spray Paint - 1 - B4B	DAS 41 9-89 OCT 29 2019
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
200 QC 5	2 pcs	11/1/19	0.00 0.00	QC 5 - 10	DAS 68 9-89 OCT 30 2019
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	

Plex 10/24/19 2:47 PM Dart.laieunesse.marie

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	2.6200 sf (1.31 ea)	110-Waterjet - Flow - 1	S215102
D4682-9	Wearplate Shim	2 pcs (1 ea)	160-Large Fab - Welded Assy-2- B4B	S167882
D4682-13	Saddle Shim	2 pcs (1 ea)	160-Large Fab - Welded Assy-2- B4B	N/A Reud.
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	M304S18GA	3	37	0
160-Large Fab - Welded Assy-2- B4B	D4682-13	2	48	0
	D4682-9	2	25	0
Part Specifications				
Specifications could not be found.				

Plex 10/24/19 2:47 PM Dart.lajeunesse.marie

ITEM	QTY	P/N	DESCRIPTION
	X	D4682-043	WEARPLATE ASSY
1	1	D4682-3	WEARPLATE
2	1	D4682-8	WEARPLATE SHIM



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 METHOD 6.1
- 7) WEIGHT: 1.20 lbs
- 8) WELDING: PER QSI 004
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK PER QSI 005 SECTION 4.9
- 10) OPEN UP DRAIN HOLE IF NECESSARY TO $\varnothing 0.188$ AFTER APPLYING TEXTURED COATING
- 11) INDICATE FWD DIRECTION IN LOCATION SHOWN USING WHITE PAINT MARKER

RELEASED
2015-06-08

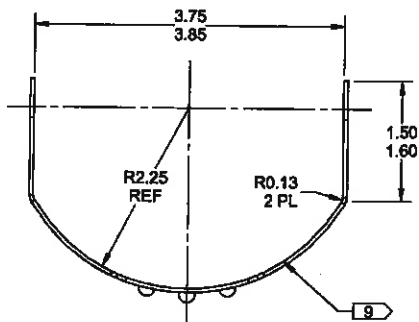
APPROVED

DESIGN	AP
DRAWN	AP
CHECKED	AJS
MFG. APPR.	DD
APPROVED	HS
DE APPR.	DS
DATE	15.03.24

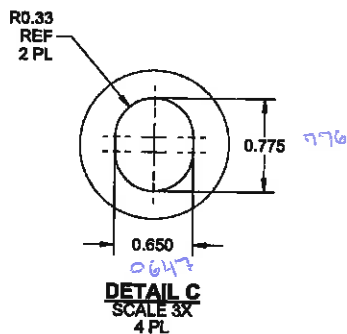
DART AEROSPACE USA, INC.
KENT, WA

DRAWING NO.	REV. D
D4682	SHEET 2 OF 8
TITLE	SCALE
WEARPLATE ASSY	NTS

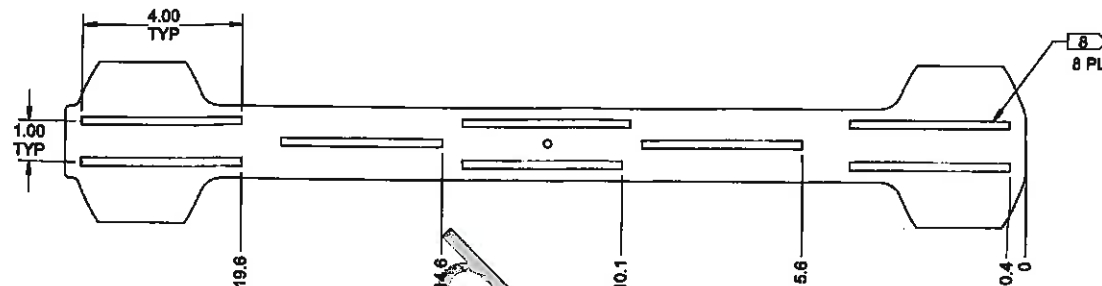
COPYRIGHT © 2013 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPLICIT CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



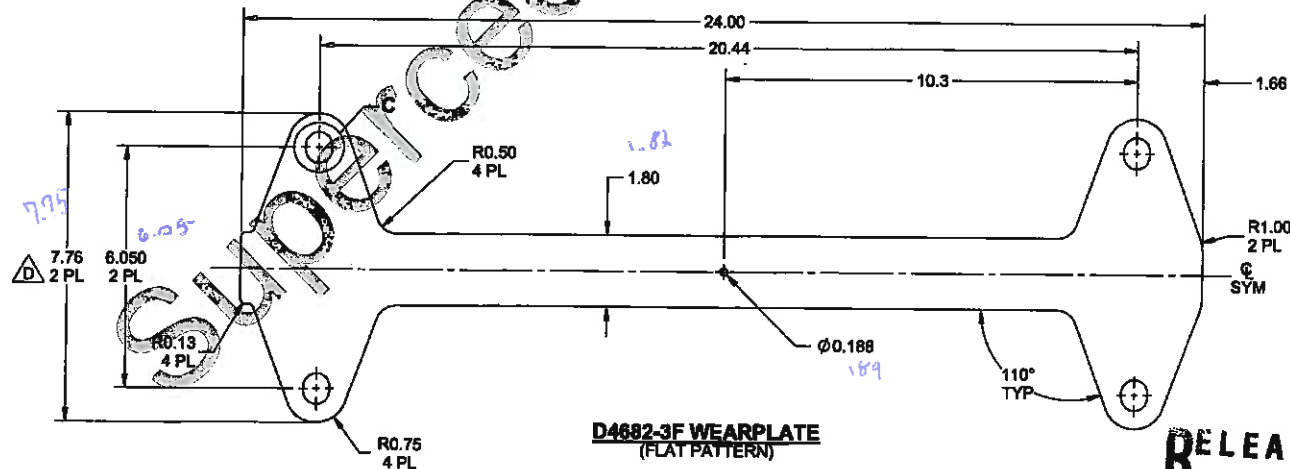
D4682-3 WEARPLATE
(AUXILIARY VIEW)



DETAIL C
SCALE 3X
4 PL



D4682-3 WEARPLATE
(MAKE FROM D4682-3F)



D4682-3F WEARPLATE
(FLAT PATTERN)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR AMS 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK, REF DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.12 lbs
- 8) WELDING: PER QSI 004. APPLY LAYER OF 2059B HARDCOAT WELD TO 0.083 - 0.125 HIGH AFTER BENDING
- 9) FORM USING R1.9 DIE

APPROVED

DESIGN	AP
DRAWN	AP
CHECKED	AJS
MFG. APPR.	DD
APPROVED	HS
DE APPR.	DS
DATE	15.03.24

DART AEROSPACE USA, INC.
KENT, WA

DRAWING NO. **D4682** REV. D
SHEET 5 OF 8
TITLE **WEARPLATE ASSY** SCALE NTS

COPYRIGHT © 2013 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE REPRODUCED OR COPIED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

RELEASED
2015-06-08

Linda Lacelle

From: Caitlin Crooks
Sent: Thursday, October 24, 2019 1:27 PM
To: Linda Lacelle
Cc: Jason Leroux; Jennifer Renwick
Subject: RE: ORDER 19947- Air Methods

They need the old

From: Linda Lacelle <llacelle@dartaero.com>
Sent: Thursday, October 24, 2019 1:24 PM
To: Caitlin Crooks <ccrooks@dartaero.com>
Cc: Jason Leroux <jleroux@dartaero.com>; Jennifer Renwick <jrenwick@dartaero.com>
Subject: RE: ORDER 19947- Air Methods

My apologies, the 1 extra old one we made got scrapped and no one told planning (surprise)...can they take the new ones? Will have to move this out 2 more weeks

From: Caitlin Crooks <ccrooks@dartaero.com>
Sent: Monday, September 30, 2019 2:36 PM
To: Linda Lacelle <llacelle@dartaero.com>
Cc: Jason Leroux <jleroux@dartaero.com>; Jennifer Renwick <jrenwick@dartaero.com>
Subject: RE: ORDER 19947- Air Methods

Old please

From: Linda Lacelle <llacelle@dartaero.com>
Sent: Monday, September 30, 2019 1:58 PM
To: Caitlin Crooks <ccrooks@dartaero.com>
Cc: Jason Leroux <jleroux@dartaero.com>; Jennifer Renwick <jrenwick@dartaero.com>
Subject: RE: ORDER 19947- Air Methods

Yes, but I better ask.. so you want the old rev or new?

From: Caitlin Crooks <ccrooks@dartaero.com>
Sent: Monday, September 30, 2019 1:46 PM
To: Linda Lacelle <llacelle@dartaero.com>
Cc: Jason Leroux <jleroux@dartaero.com>; Jennifer Renwick <jrenwick@dartaero.com>
Subject: RE: ORDER 19947- Air Methods

New rev? aren't we supposed to be selling the latest rev

From: Linda Lacelle <llacelle@dartaero.com>
Sent: Monday, September 30, 2019 1:34 PM
To: Caitlin Crooks <ccrooks@dartaero.com>
Cc: Jason Leroux <jleroux@dartaero.com>; Jennifer Renwick <jrenwick@dartaero.com>
Subject: RE: ORDER 19947- Air Methods

Sigh...
Old rev or new rev?

From: Caitlin Crooks <ccrooks@dartaero.com>
Sent: Monday, September 30, 2019 1:27 PM
To: Linda Lacelle <llacelle@dartaero.com>; Marie Lajeunesse <mlajeunesse@dartaero.com>; Jennifer Renwick <jrenwick@dartaero.com>; Jason Leroux <jleroux@dartaero.com>
Subject: ORDER 19947- Air Methods

Please see attached

If there are any questions, do not hesitate to ask.

Thank you,
Caitlin

CAITLIN CROOKS
Inside Sales Representative

DART AEROSPACE
T 1 613 632-3336 > 289
F 1 613 632-4443
M 1 613 306-0596
E ccrooks@dartaero.com

1 800 556- 4166

www.dartaerospace.com

For *technical support*, click [here](#).

To access *technical documentation*, create your account [here](#).



Entered: NR Date: Nov 8/19NCR No. 19-7700

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

Job: <u>202331</u> Part No. <u>D4682-043</u>		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☒ Water Jet ☐ Supplier Quality ☐							
Date: <u>19/10/24</u>		Sequence #:		QTY Affected: <u>4</u>		MRB (QSI042) <u>INSP 12</u> <u>19/10/24</u>					
Description Work Order Deviation				Disposition							
D4682 Rev.D) wecrplates are required to complete D45-762-013 Skid tubes @ CHG UOS, which were in production at release of new draws and are acceptable to sell.				Acceptable to cut and form wecrplate per D4682 Rev.D. Minor deviation Minor deviation to Reu.F required to complete existing production.							
								Completed By <u>19/10/24</u>			
								Lead hand / Supervisor DAS 69 <u>19/10/24</u> 9-89			
QC / QA Coordinator DAS 55 9-89 NOV 07 2019											
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☒ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☒ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread									
		Other/Details:									